



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

close

D3065-3
Job Sheet 178560



Part No: D3065-3

Job Qty: 40 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		6/22/18	0.00	0.00	Start Up Waterjet		<i>SC 18/06/11</i>
100	Waterjet	40 pcs		6/22/18	0.00	1.84	Waterjet1		<i>SC 18/06/11</i>
120	QC	40 pcs		6/22/18	0.00	0.00	QC8		<i>EB</i>
140	Brake NC	40 pcs		6/22/18	0.02	1.88	Brake NC 1		<i>DAB 38</i>
150	QC	40 pcs		6/22/18	0.00	0.00	QC5		<i>BEB 18-06-26</i>
160	HandFinish	40 pcs		6/22/18	0.00	0.82	HandFinish1		<i>EB</i>
170	QC	40 pcs		6/22/18	0.00	0.00	QC7-1		<i>EB</i>
180	Packaging	40 pcs		6/22/18	0.00	0.00	Packaging3-1		<i>EB</i>
190	QC21-SA	40 Ea		6/22/18	0.00	0.00	QC21		<i>EB</i> JUN 26 2018

Part Op 100 - 1-Cut as per Dwg Rev: *B*

Descriptions: 140 - Bend as per Dwg D3065

180 - LOCATION : GA

21
9-80

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	8.7120 sf (.2178 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	9	171	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	1.260inches ± 0.010	1.270 1.250	<i>1,265</i>	
2	Step Spacer	3.260inches ± 0.010	3.270 3.250	<i>3,263</i>	
3	Step Spacer	5.260inches ± 0.010	5.270 5.250	<i>5,262</i>	
4	Step Spacer	6.520inches ± 0.010	6.530 6.510	<i>6,524</i>	
5	Step Spacer	2.093inches ± 0.010	2.103 2.083	<i>2,090</i>	



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Work Order: _____	Suspected Unapproved	Skid-tube	Cross tube	Water Jet	Engineering
Part No. _____		Machining	Small Fab	Prod. Eng. Coord.	Quality
NCR No. _____		Thermoforming	Finishing	Rec/Store/Packaging	Other
Date: _____	Step #: _____	QTY Effective: _____			
Description Work Order Deviation					
MRB (QS042) Approval					

DART
AEROSPACE

Container No: S080024

Part: D3065 - 3
Job No: 178560
Serial No/Batch: S080024

Revision:
Inspector:
Exp Date:
Instructions:

Date: 06/11/18

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CANADA
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Email: sales@dartaero.com
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Environment	No Re-verification	Pressure/Forced
Design	Operator	Bending
Doc/Data	Offset/Setup	Centre Not Concentric
Equip/Tooling	Supplier	Cracks
Handling/Pre	Training	Crimp/Kink/Ripple/Weld
Material	Use for Testing	Cuffs
Internal Transport	Poor Information	Crushing
Tribal Knowledge	Rushing	Heat Treat
LOA	Product Improvement	Wave/Twist in Tube
Substation	Process Improvement	Marks/Chatter
Past Expiry Date	Manufacturing Process	
Misidentified	Past Due	OTHER: _____

Countersink	Off-set	Part Moved
Cut Too Short	Mislabeled	Drawing
Instructions Incomplete/Unclear	Fit/Function	Finish
Drill Holes	Misaligned/off center	Misread
		Turning Sequence

6	Step Spacer	3.936inches $\pm$ 0.010	3.946 3.926	3,940
7	Step Spacer	4.186inches $\pm$ 0.010	4.196 4.176	4,190
8	Step Spacer	0.129inches + 0.005 - 0.000	0.134 0.129	0,130
9	Step Spacer	1.250inches + 0.005 - 0.000	1.255 1.250	1,252
10	Step Spacer	1.204inches $\pm$ 0.005	1.209 1.199	1,204
11	Step Spacer	0.040inches $\pm$ 0.010	0.050 0.030	0,040

Plex 6/1/18 2:51 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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